

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021643**Date Inspected:** 08-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segments**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Trial Assembly Yard

Segment 12AE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) joint. The Weld joint is designated CA3001-006, Side Plate to Edge Plate hold back weld. The welder is identified as #067752 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-TC-U4b-FCM-1.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) joint. The Weld joint is designated CA6501-001, Side Plate to Edge Plate hold back weld. The welder is identified as #067752 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-TC-U4b-FCM-1.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet joint. The Weld joint is designated DP3011-001-018, Deck Plate I-rib hold back. The welder is identified as #040270 and was observed

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welding in the 4F (overhead) position using approved Welding Procedure Specification WPS-B-T-4114-1.

Segment 12AW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) joint. The Weld joint is designated CA3012-001, Side Plate to Edge Plate hold back weld. The welder is identified as #046709 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-TC-U4b-FCM-1.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet joint. The Weld joint is designated SP3049-001-019, 020, Side Plate I-rib hold back. The welder is identified as #057333 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2112-FCM-1.

For the above mentioned welding activities ZPMC Quality Control (QC) Inspectors are identified as Wang Zhou and Zhou Peng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 12CW

This QA Inspector observed ABF personnel performing Ultrasonic Testing on the Bottom Plate to Side Plate hold back weld, counter weight side at west end of segment.

This QA Inspector observed beveling of the Side Plate longitudinal splice at the segment Side Plate and Corner Assembly Side Plate.

Segment 12BE/12CE

This QA Inspector observed ABF personnel performing Magnetic Particle Testing on the Deck Plate transverse splice including locations of removed fit up plates.

Cross Beam 17

This QA Inspector observed grinding of the weld crown on the Side Panel to Bottom Panel at panel point 110 and Side Panel to Deck Panel at panel point 112.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for your project.

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Inspected By:	Hernandez,Dan	Quality Assurance Inspector
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Reviewed By:	Miller,Mark	QA Reviewer
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